

Work Order ID 110896

110896

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January-08-14 12:39:27 PM

Item ID: D4522-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Latch Assembly, LH, Oem
 Start Date: 1/08/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/08/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-01-09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4522	B								
100	Pick Kit	0.00							
100	FLOW WATER JET								FF
Packaging	Memo	0.00							05-02-14
Packaging									
110		0.00							
110									FF
Small Fab	Memo	0.00							05-02-14
Small Fab	ASSEMBLE DOOR LATCH AS PER DWG								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
16
9-89 14/02/05

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Work Order ID 110896

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Item ID: D4522-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Latch Assembly, LH, Oem
Start Date: 1/08/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/08/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo <i>ST/39/E</i>	0.00						<i>6/2/6</i>	<i>(i)</i>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00						<i>14-02-6</i>	
Quality Control								<i>14-02-06</i>	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 1

Work Order ID: 110896

Parent Item: D4522-041

Parent Item Name: Door Latch Assembly, LH, Oem

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.12.21 NEW ISSUE DD VERF:JLM
12/07/05 JFS VERF: JLM

IPP REV:B AS PER REV.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4522-1 Base Plate, Oem, LH		Manufactured	No	396970		100	Each	4.0000	1	1	FF	05-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST110		4							
				96970		4							
✓ D4522-9 Vertical Swing Arm		Manufactured	No			100	Each	5.0000	1	1	FF	05-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST110		5							
				80395		2				1			
				96971		3							
✓ D4522-11 Handle Shaft Arm		Manufactured	No			100	Each	9.0000	1	1	FF	05-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST110		9							
				80386		2							
				96968		3				1			
				98249		4							
✓ D4522-13 Handle Shaft Adapter		Manufactured	No			100	Each	7.0000	1	1	FF	05-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST110		7							
				96084		7				1			
✓ D4522-17 Linkage		Manufactured	No			100	Each	15.0000	2	2	FF	05-02-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST111		15							
				86620		3				2			
				98250		12							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Work Order ID: 110896

Parent Item: D4522-041

Parent Item Name: Door Latch Assembly, LH, Oem

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

✓	D4522-19	Manufactured	No	100	Each	10.0000	2	2	FF	05-02-14
	Linkage									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		ST111		10						
		83063		8						
		86621		2				2		
✓	D4522-21	Manufactured	No	100	Each	17.0000	2	2	FF	05-02-14
	Linkage									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		CA		17						
		96290		2				2		
		98251		15						
✓	D4522-25	Manufactured	No	100	Each	12.0000	1	1	FF	05-02-14
	Latch Shaft									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		ST111		12						
		96085		6				1		
		98252		6						
✓	D4522-045	Manufactured	No	100	Each	9.0000	1	1	FF	05-02-14
	Base, Horizontal Swing Arm									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		ST111		9						
		80383		2						
		96088		2						
		98246		5				1		
✓	D4522-047	Manufactured	No	100	Each	8.0000	1	1	FF	05-02-14
	Base, Vertical Swing Arm									
		<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
		ST111		8						
		96086		3						
		98247		5				1		

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

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Work Order ID: 110896

Parent Item: D4522-041

Parent Item Name: Door Latch Assembly, LH, Oem

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

✓ D4522-049	Manufactured	No		100	Each	7.0000	1	1	FF 05-02-14
Base, Latch Shaft									
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
			ST111	7					
			96087	3					
			98248	4					
✂ D4529-041	Manufactured	No	112640	100	Each	0.0000	1	1	FF 05-02-14
Horizontal Swing Arm			89227						
✓ D4530-041	Manufactured	No		100	Each	1.0000	1	1	FF 05-02-14
Latch Roller Assembly									
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
			GA	1					
			110901	1					
			92178						
✓ D4531-1	Manufactured	No		100	Each	10.0000	1	1	FF 05-02-14
Latch Shaft Bracket									
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
			GA	10					
			96293	4					
			98254	6					
✓ D4574-1	Manufactured	No		100	Each	6.0000	1	1	FF 05-02-14
Interior L-Handle, Modified									
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
			CA	5					
			96294	5					
			ST112	1					
			86628	1					
✓ D4588-1	Manufactured	No		100	Each	94.0000	1	1	FF 05-02-14
Torsion Spring									
			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>			
			CA	46					
			78930	46					
			ST112	48					
			86611	48					

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 4

Work Order ID: 110896

Parent Item: D4522-041

Parent Item Name: Door Latch Assembly, LH, Oem

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

D4626-1	Manufactured	No	100	Each	7.0000	1	1	FF 05-02-14
Spring								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		CA	7					
		87005	7					
MS20995-C20	Purchased	No	100	f	1,000.0000	1	1	FF 05-02-14
Lockwire								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		GA	1000					
		106074	1000					
MS16562-193	Purchased	No	100	Each	89.0000	1	1	FF 05-02-14
Spring Pin								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST331	89					
		120229	89					
MS16562-223	Purchased	No	100	Each	88.0000	1	1	FF 05-02-14
Spring Pin								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST331	88					
		120229	88					
MS16562-227	Purchased	No	100	Each	99.0000	1	1	FF 05-02-14
Spring Pin								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST331	99					
		120595	99					
MS16624-4062	Purchased	No	100	Each	22.0000	1	1	FF 05-02-14
External Retaining Ring								
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
		ST331	22					
		121259	3					
		122389	19					

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Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

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Page 5

Work Order ID: 110896

Parent Item: D4522-041

Parent Item Name: Door Latch Assembly, LH, Oem

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

MS20392-1P41

Purchased

No

100

Each

11.0000

1

1

FF 05-02-14

Drilled Pin

Location

Loc Qty

Loc Code

ST333

11

120250

2

122389

9

1

MS20392-1R27P

Purchased

No

100

Each

10.0000

1

1

FF 05-02-14

Drilled Pin

Location

Loc Qty

Loc Code

ST333

10

124650

10

124818

1

MS20392-1R37P

Purchased

No

100

Each

0.0000

1

1

FF 05-02-14

Drilled Pin

MS20392-1R9P

Purchased

No

100

Each

1.0000

4

4

FF 05-02-14

Drilled Pin

Location

Loc Qty

Loc Code

ST333

1

125769

1

120872

4

MS20392-2R41P

Purchased

No

100

Each

25.0000

3

3

FF 05-02-14

Drilled Pin

Location

Loc Qty

Loc Code

ST333

25

120650

1

124818

10

m120872

2

m125769

5

m125840

7

1

January-08-14 12:39:26 PM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____
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Picklist Print

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Page 6

Work Order ID: 110896

Parent Item: D4522-041

Parent Item Name: Door Latch Assembly, LH, Oem

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

✓ MS24665-151

Cotter Pin

Purchased

No

100

Each

142.0000

7

7

FF 05-02-14

Location

Loc Qty

Loc Code

GA

29

17566

29

ST323

113

125646

13

m127305

100

✓ MS24665-155

Cotter Pin

Purchased

No

100

Each

9.0000

2

2

FF 05-02-14

Location

Loc Qty

Loc Code

ST299

9

127924

9

m126254

✓ MS24671-14

Flat Head Screw, Hex, #8

Purchased

No

100

Each

68.0000

6

6

FF 05-02-14

Location

Loc Qty

Loc Code

ST299

68

120229

68

✓ MS24674-13

Drilled Cap Screw, #10

Purchased

No

100

Each

25.0000

1

1

FF 05-02-14

Location

Loc Qty

Loc Code

ST299

25

120305

15

124327

10

✓ NAS1149CN432R

Flat Washer

Purchased

No

100

Each

173.0000

5

5

FF 05-02-14

Location

Loc Qty

Loc Code

ST291

173

105940

73

120177

100

January-08-14 12:39:26 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 7

Work Order ID: 110896

Parent Item: D4522-041

Parent Item Name: Door Latch Assembly, LH, Oem

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 1.00

Required Qty: 1.00

NAS42DD628FC

Purchased

No

100

Each

95.0000

1

1

Spacer

PP 05-02-14

Location

Loc Qty

Loc Code

ST275

95

120229

95

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

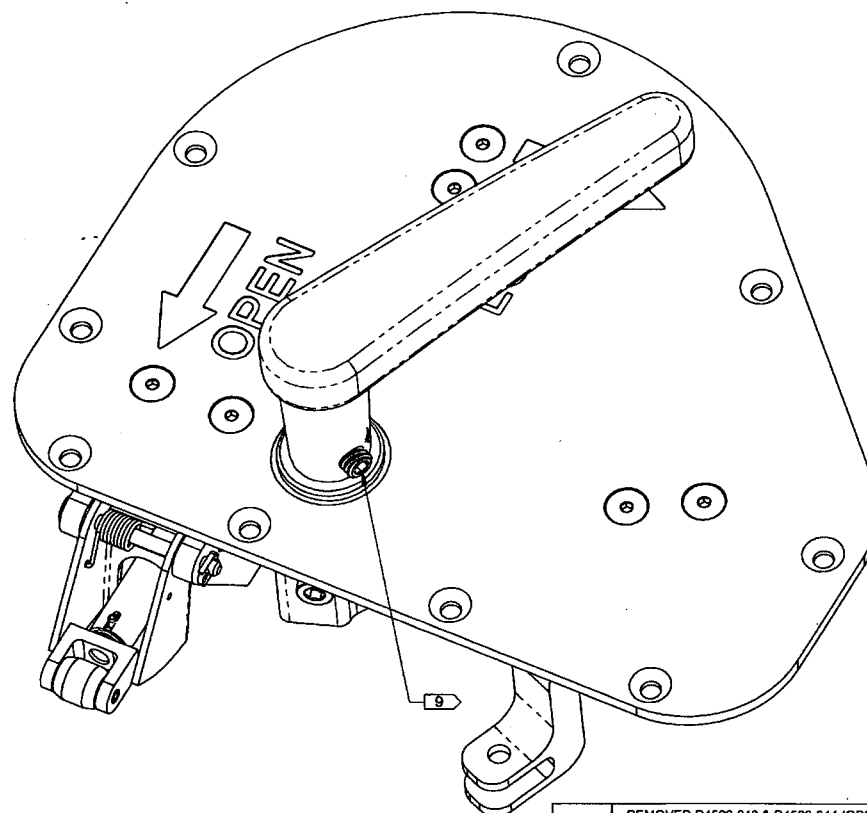
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

ITEM	QTY	P/N	DESCRIPTION
1	X	D4522-041	DOOR LATCH ASSY, LH, OEM
1	1	D4522-1	BASE PLATE, OEM (LH)
2	1	D4522-9	VERTICAL SWING ARM
3	1	D4522-11	HANDLE SHAFT ARM
4	1	D4522-13	HANDLE SHAFT ADAPTER
5	2	D4522-17	LINKAGE
6	2	D4522-19	LINKAGE
7	2	D4522-21	LINKAGE
8	1	D4522-25	LATCH SHAFT
9	1	D4522-045	BASE, HORIZONTAL SWING ARM
10	1	D4522-047	BASE, VERTICAL SWING ARM
11	1	D4522-049	BASE, LATCH SHAFT
12	1	D4529-041	HORIZONTAL SWING ARM
13	1	D4530-041	LATCH ROLLER
14	1	D4531-1	LATCH SHAFT BRACKET
15	1	D4574-1	INTERIOR L-HANDLE
16	1	D4588-1	TORSION SPRING
17	1	D4626-1	EXTENSION SPRING
18	1	MS-20995-C20	LOCK WIRE
19	1	MS16562-193	SPRING PIN
20	1	MS16562-223	SPRING PIN
21	1	MS16562-227	SPRING PIN
22	1	MS16624-4062	EXTERNAL RETAINING RING
23	1	MS20392-1P41	DRILLED PIN
24	1	MS20392-1R27P	DRILLED PIN
25	1	MS20392-1R37P	DRILLED PIN
26	4	MS20392-1R9P	DRILLED PIN
27	3	MS20392-2R41P	DRILLED PIN
28	7	MS24665-151	COTTER PIN
29	2	MS24665-155	COTTER PIN
30	6	MS24671-14	SCREW, FL-HD, HEX, #8
31	1	MS24674-13	DRILLED CAP SCREW, #10
32	5	NAS1149-C-N432-R	FLAT WASHER
33	1	NAS42DD628FC	SPACER




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14-01-09

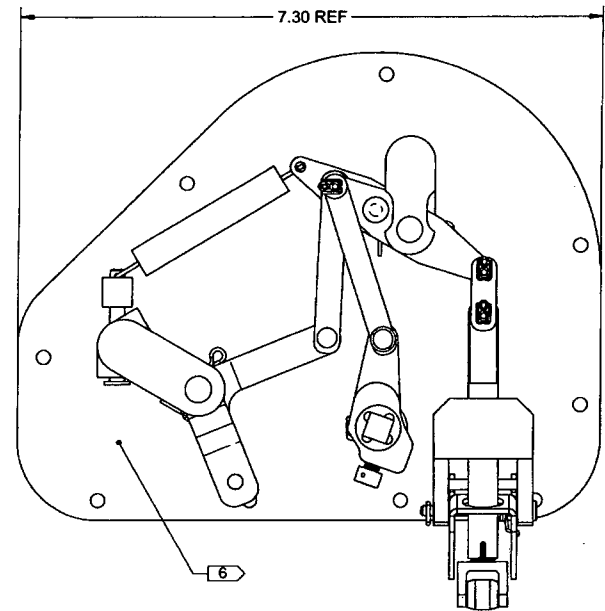
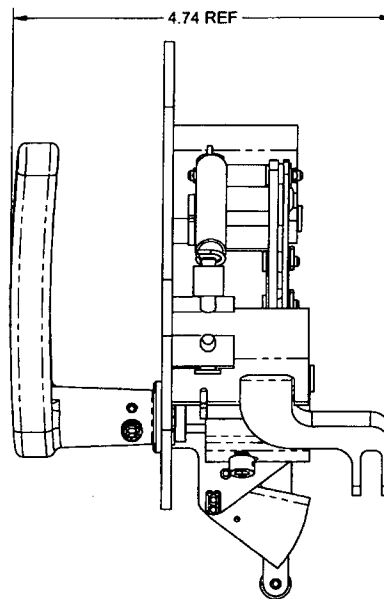
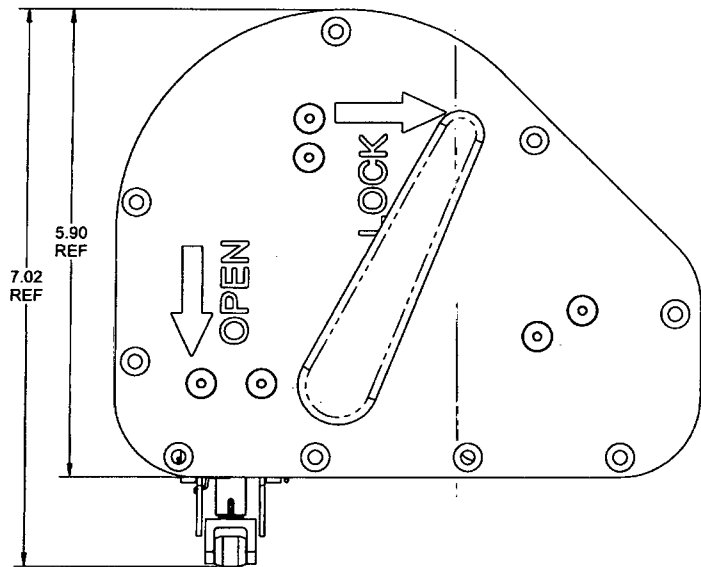
RELEASED
2012-06-13

D4522-041 DOOR LATCH ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: MARK PART NUMBER AND BATCH NUMBER PER DART QSI 044 6.4
- 7) WEIGHT: 2.0 lbs
- 8) INSTALL ALL COTTER PINS AND LOCK WIRE IN ACCORDANCE WITH MS33540
- 9) APPLY LOCTITE 262 TO HANDLE THREADS PRIOR TO TIGHTENING SET SCREW
- 10) SHEETS 21 - 23 ARE FOR REFERENCE ONLY AND ARE MERELY **RECOMMENDED** ASSEMBLY STEPS

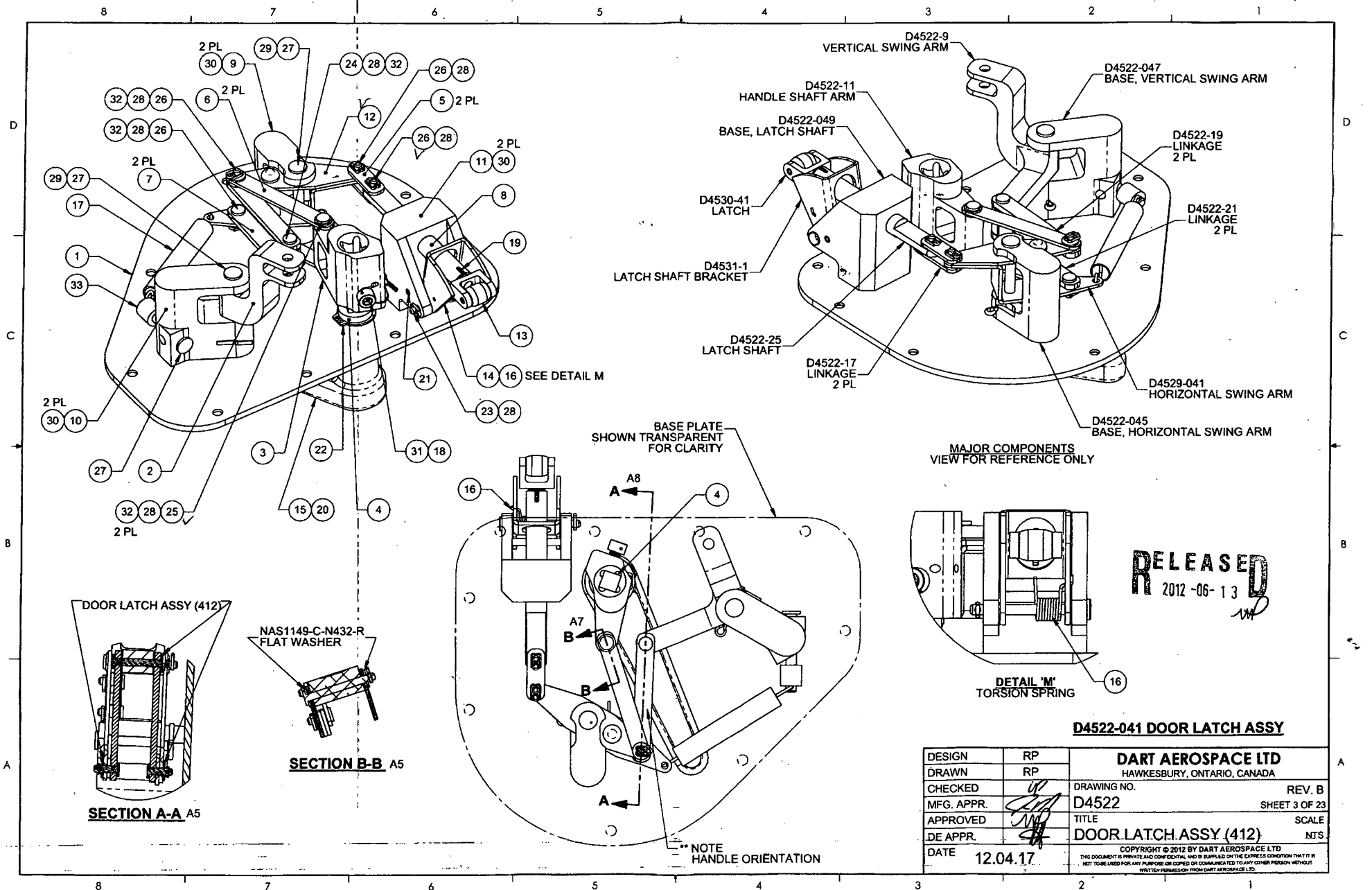
B	- REMOVED D4522-043 & D4522-044 (OBSOLETE) - ADDED SPOT-FACE TO D4522-1 & D4522-2 (D7-7 & C2-8 RESPECTIVELY) - OPTIMIZED CORNER, CLEARANCE NOTCHES IN D4522-11 & D4522-12 (C4-14 & C7-15 RESPECTIVELY) - OPTIMIZED SIZE AND TOLERANCES OF RETAINING RING GROOVE IN D4522-13 (C5-18) - ASSIGNED DART PART NUMBERS TO SPRINGS FROM: T032-180-156L TO: D4588-1 (C8-1, C8-4) FROM: LE0450055 TO: D4626-1 (C8-1 & C8-4)		RP	12.04.17
	A	NEW ISSUE	RP	12.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RP			
CHECKED			DRAWING NO.	REV.
MFG. APPR.			D4522	SHEET 1 OF 23
APPROVED			TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS	
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		



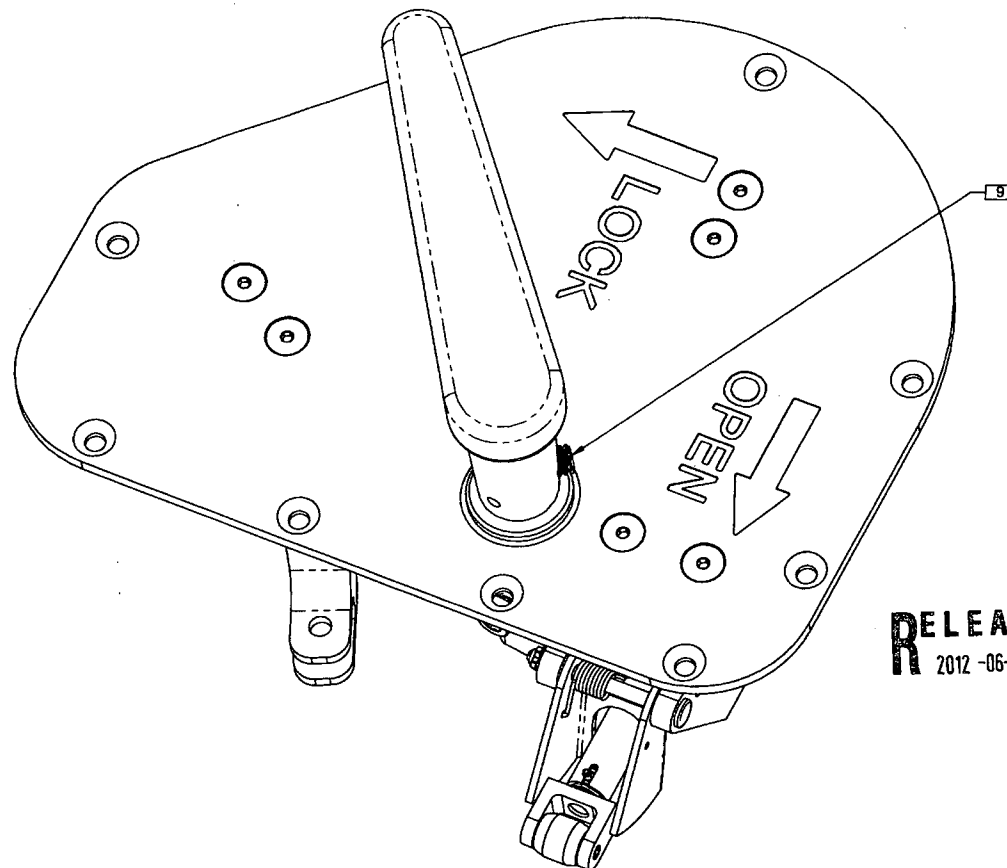
D4522-041 DOOR LATCH ASSY

RELEASED
2012-06-13
MD

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4522	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 23	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR LATCH ASSY (412)	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	1	D4522-042	DOOR LATCH ASSY, RH, OEM
2	1	D4522-2	BASE PLATE, OEM (RH)
3	1	D4522-10	VERTICAL SWING ARM
4	1	D4522-12	HANDLE SHAFT ARM
5	1	D4522-13	HANDLE SHAFT ADAPTER
6	2	D4522-17	LINKAGE
7	2	D4522-19	LINKAGE
8	2	D4522-21	LINKAGE
9	1	D4522-25	LATCH SHAFT
10	1	D4522-045	BASE, HORIZONTAL SWING ARM
11	1	D4522-047	BASE, VERTICAL SWING ARM
12	1	D4522-049	BASE, LATCH SHAFT
13	1	D4529-041	HORIZONTAL SWING ARM
14	1	D4530-041	LATCH ROLLER
15	1	D4531-1	LATCH SHAFT BRACKET
16	1	D4574-1	INTERIOR L-HANDLE
17	1	D4588-1	TORSION SPRING
18	1	D4626-1	EXTENSION SPRING
19	1	MS-20995-C20	LOCK WIRE
20	1	MS16562-193	SPRING PIN
21	1	MS16562-223	SPRING PIN
22	1	MS16562-227	SPRING PIN
23	1	MS16624-4062	EXTERNAL RETAINING RING
24	1	MS20392-1P41	DRILLED PIN
25	1	MS20392-1R27P	DRILLED PIN
26	1	MS20392-1R37P	DRILLED PIN
27	4	MS20392-1R9P	DRILLED PIN
28	3	MS20392-2R41P	DRILLED PIN
29	7	MS24665-151	COTTER PIN
30	2	MS24665-155	COTTER PIN
31	60	MS24671-14	SCREW, FL-HD, HEX, #8
32	1	MS24674-13	DRILLED CAP SCREW, #10
33	5	NAS1149-C-N432-R	FLAT WASHER
34	1	NAS42DD628FC	SPACER







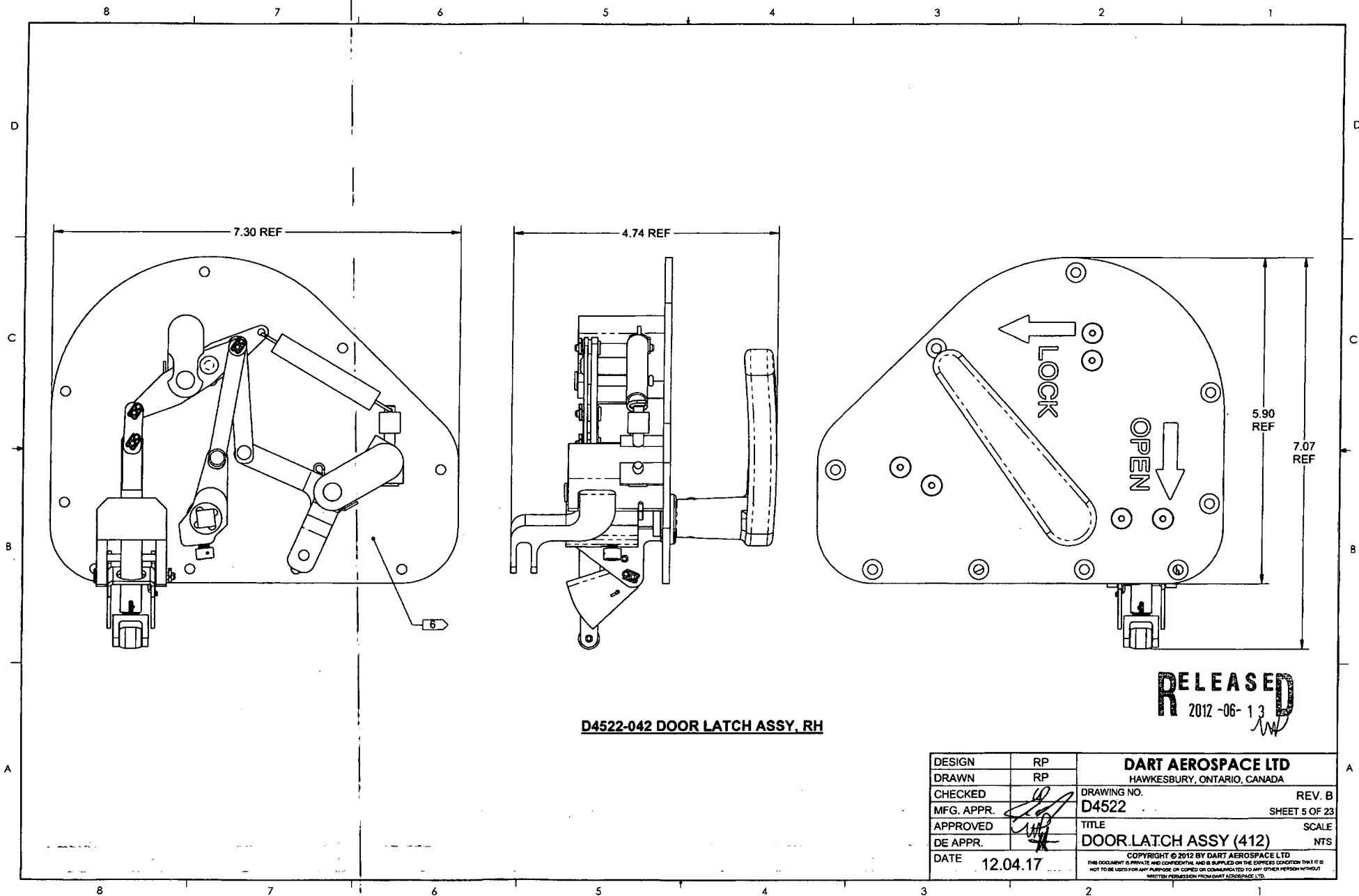
RELEASED
2012-06-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: MARK PART NUMBER AND BATCH NUMBER PER DART QSI 044 6.4
- 7) WEIGHT: 2.0 lbs
- 8) INSTALL ALL COTTER PINS AND LOCK WIRE IN ACCORDANCE WITH MS33540
- 9) APPLY LOCTITE 262 TO HANDLE THREADS PRIOR TO TIGHTENING SET SCREW
- 10) SHEETS 21-23 ARE FOR REFERENCE ONLY AND ARE MERELY **RECOMMENDED** ASSEMBLY STEPS

D4522-042 DOOR LATCH ASSY, RH

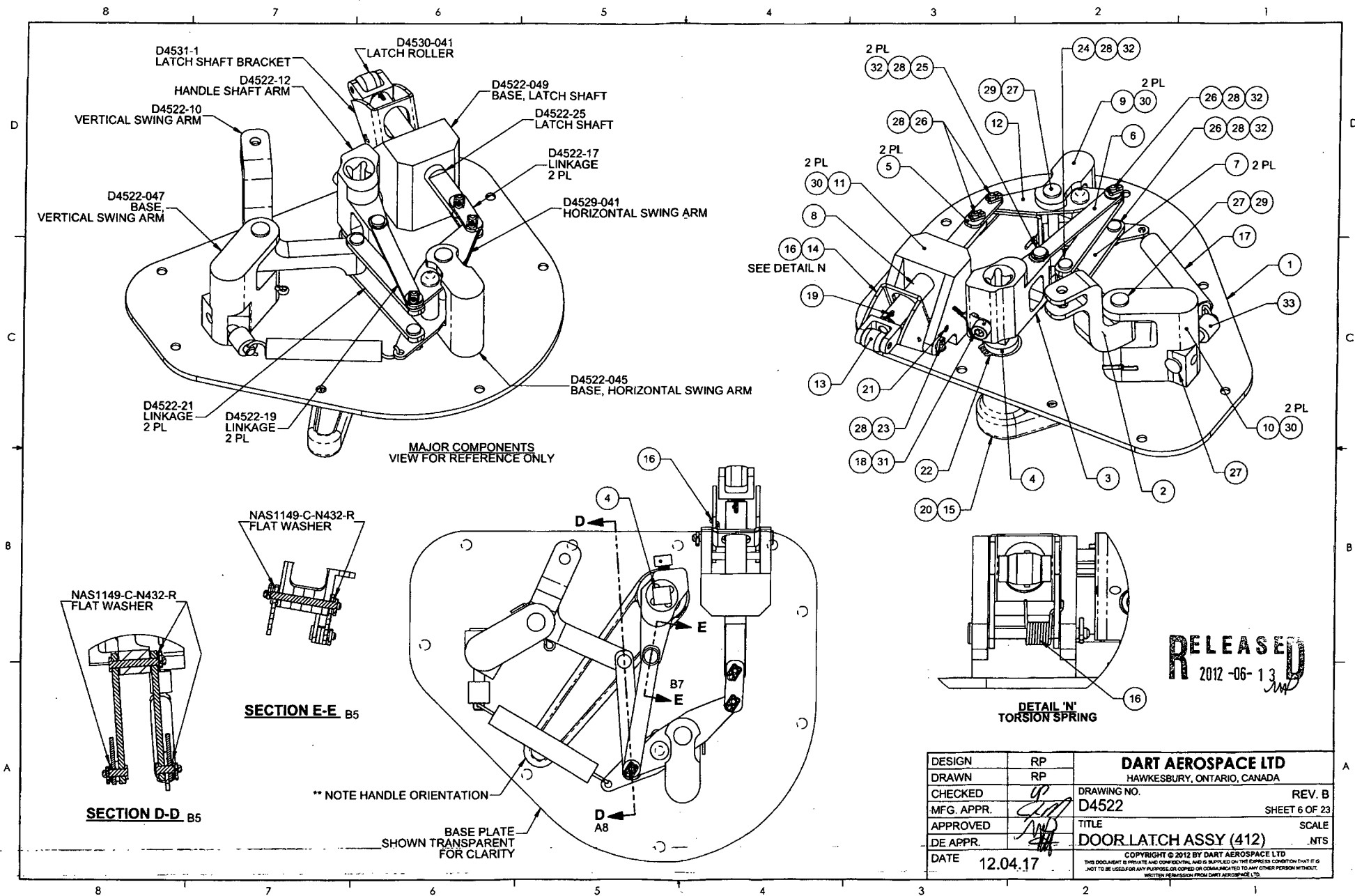
DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 4 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
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D4522-042 DOOR LATCH ASSY, RH

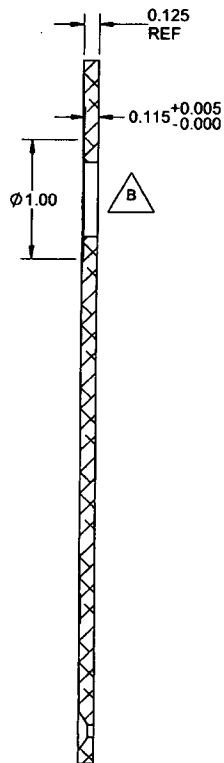
RELEASED
 2012-06-13
W

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4522	SHEET 5 OF 23
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR LATCH ASSY (412)	NTS
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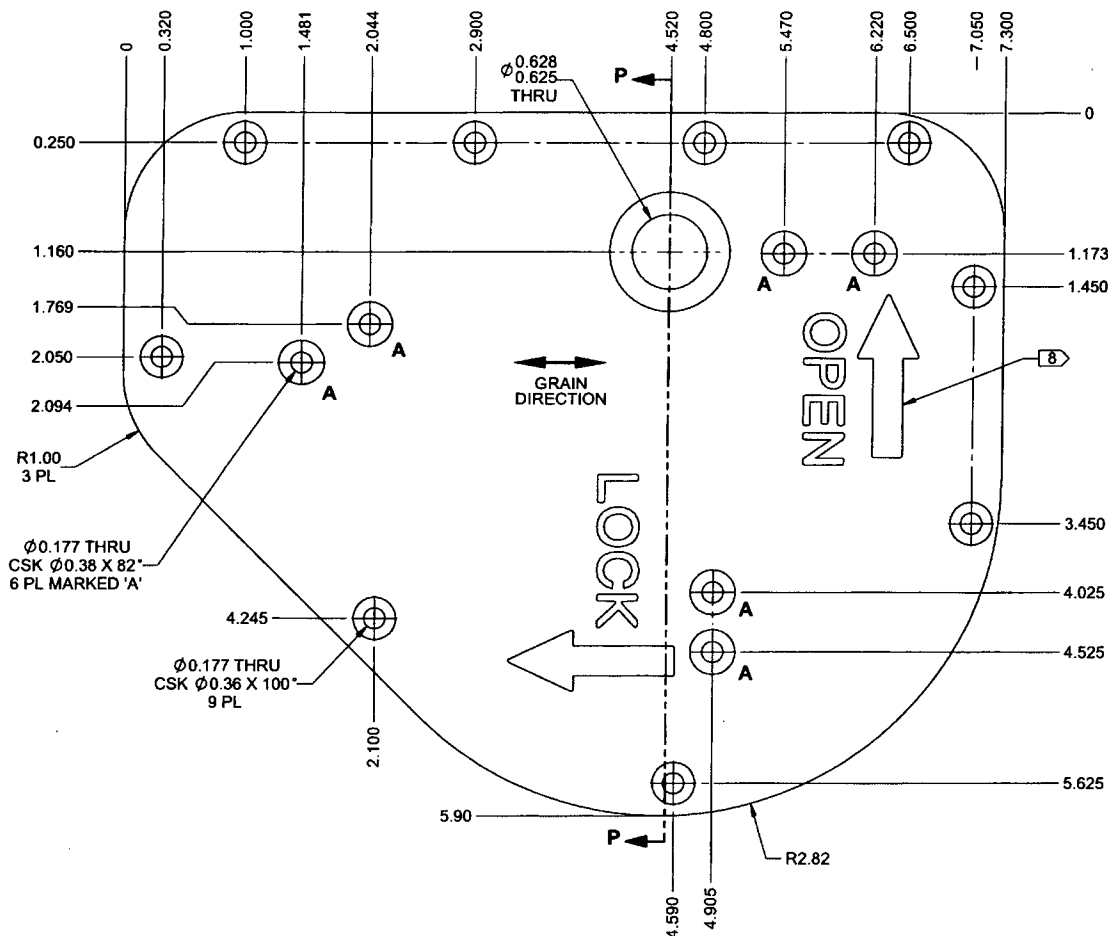


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2012-06-13

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 6 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
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SECTION P-P



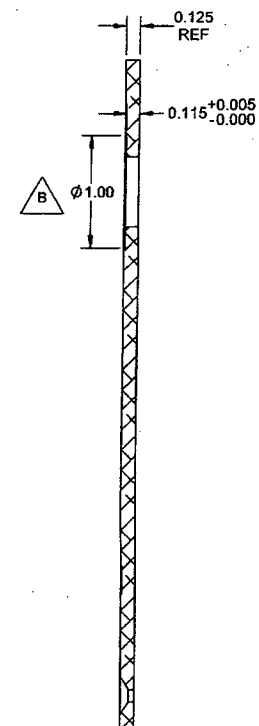
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT ANSI 61 (4.3.5.15) GREY PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.4 lbs
- 8) ENGRAVE TEXT AND ARROWS .010" DP IN APPROXIMATE LOCATION SHOWN. TEXT TO BE APPROX. 0.32 HIGH

D4522-1 BASE PLATE, OEM (LH)


DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 7 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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2012-06-13

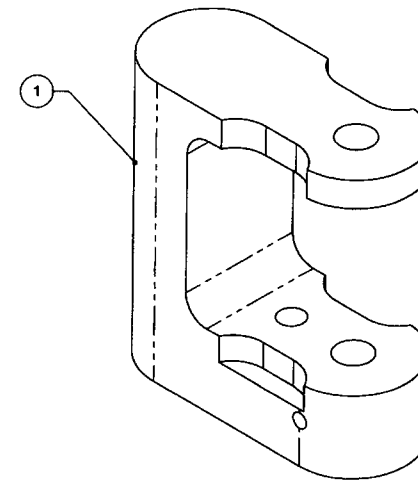
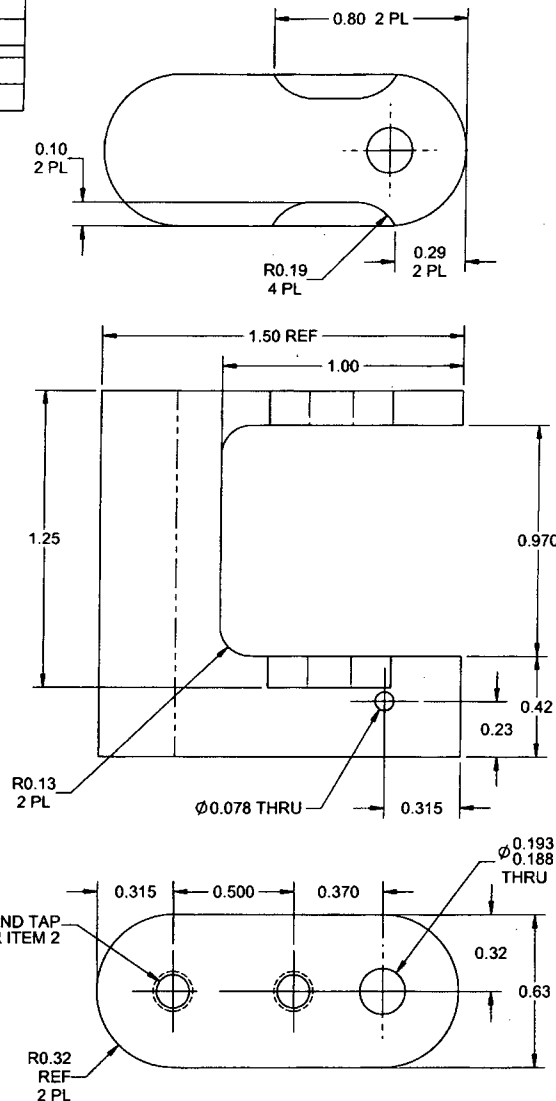
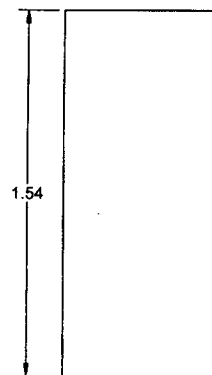


RELEASE
2012-06-13

D4522-2 BASE PLATE, OEM (RH)

DESIGN	RP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RP		DRAWING NO. D4522	REV. B	
CHECKED	AP			SHEET 8 OF 23	
MFG. APPR.					
APPROVED				TITLE DOOR LATCH ASSY (412)	SCALE NTS
DE APPR.					
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ITEM	QTY	P/N	DESCRIPTION
	X	D4522-045	BASE, HORIZONTAL SWING ARM
1	1	D4522-3	BASE, HORIZONTAL SWING ARM
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG





NOTES:

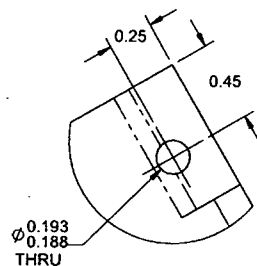
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.07 lbs

D4522-045 BASE, HORIZONTAL SWING ARM

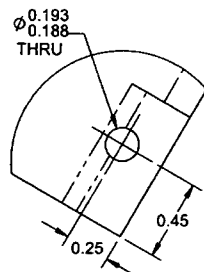
RELEASED
2012-06-13

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 9 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
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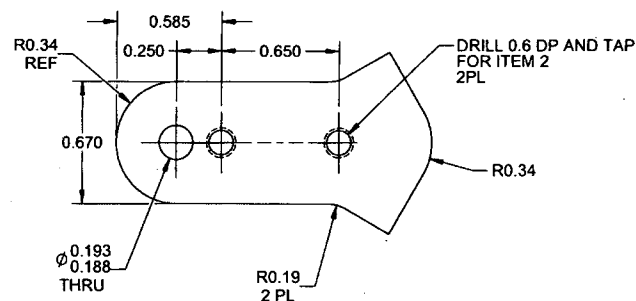
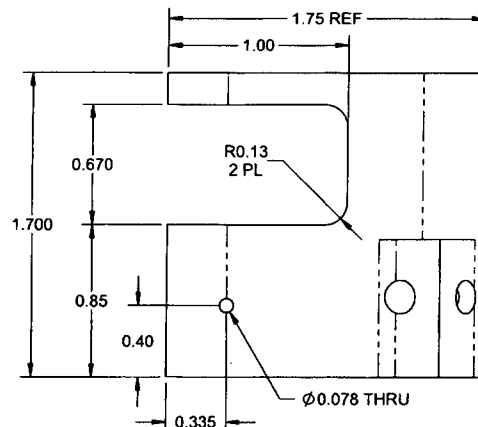
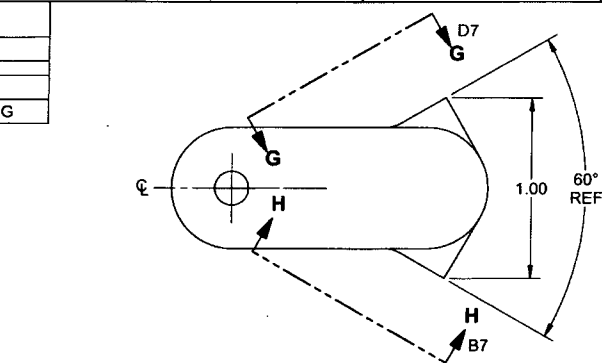
ITEM	QTY	P/N	DESCRIPTION
	X	D4522-047	BASE, VERTICAL SWING ARM
1	1	D4522-5	BASE, VERTICAL SWING ARM
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



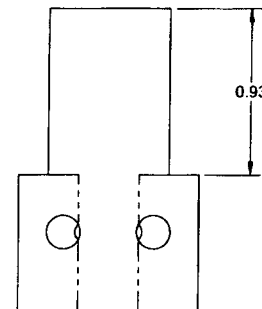
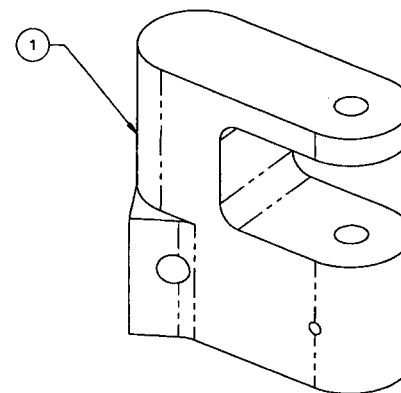
VIEW G-G D4



VIEW H-H C4





D4522-047 BASE, VERTICAL SWING ARM

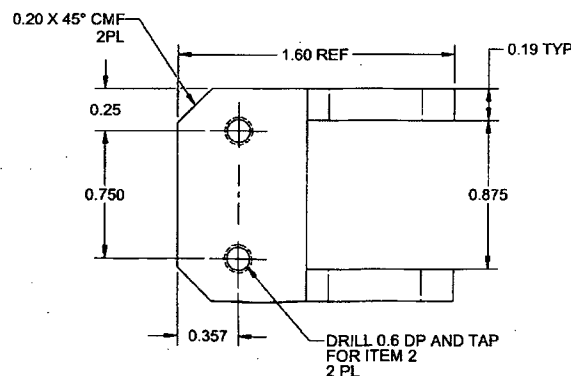
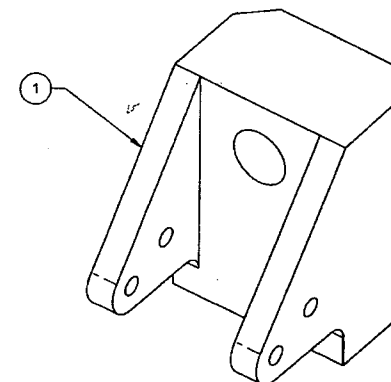
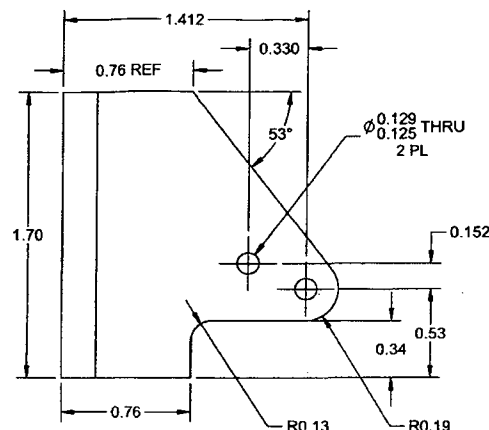
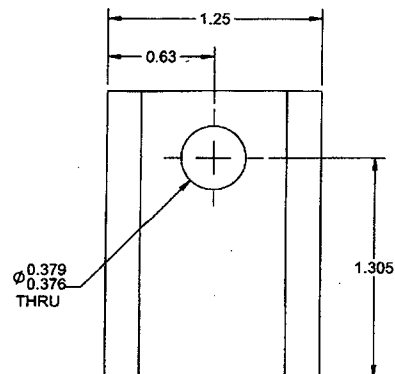


- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
 - 7) WEIGHT: 0.14 lbs

RELEASED
2012-06-13

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 10 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR-LATCH ASSY (412)	NTS
DATE	12.04.17	--- COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM	QTY	P/N	DESCRIPTION
	X	D4522-049	BASE, LATCH SHAFT
1	1	D4522-7	BASE, LATCH SHAFT
2	12	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



NOTES:

1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR
AMS4117/4128/4115/4116 OR QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED



5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

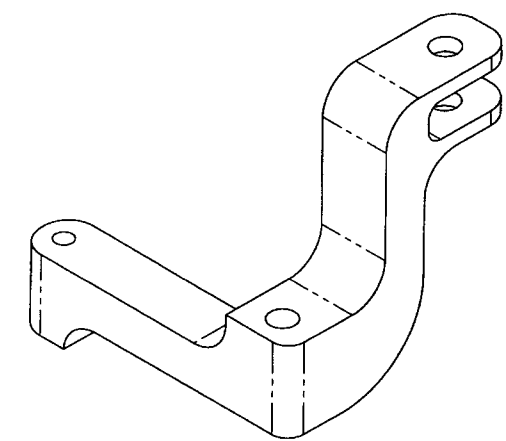
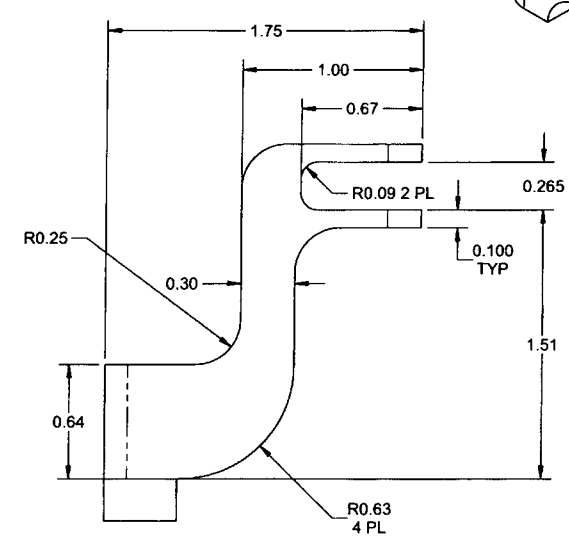
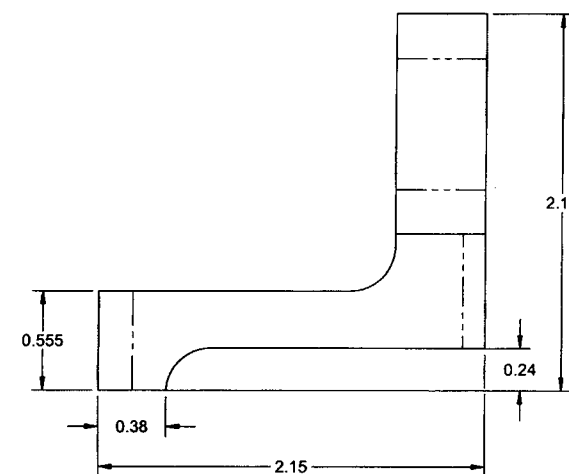
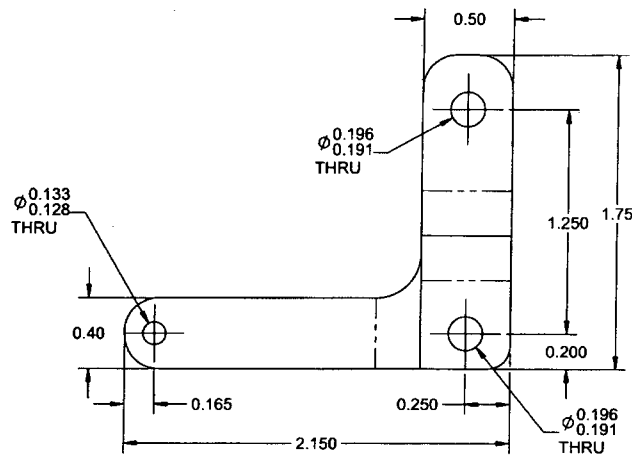
6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7

7) WEIGHT: 0.16 lbs

D4522-049 BASE, LATCH SHAFT

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DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4522	SHEET 11 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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



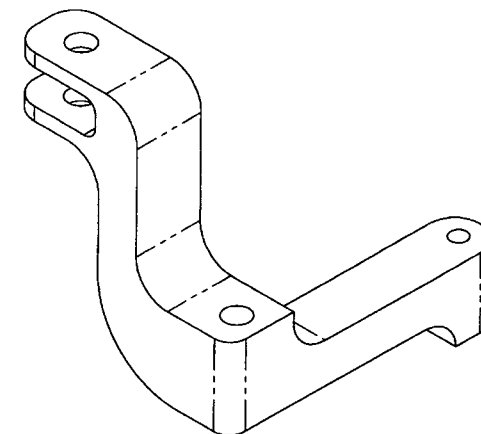
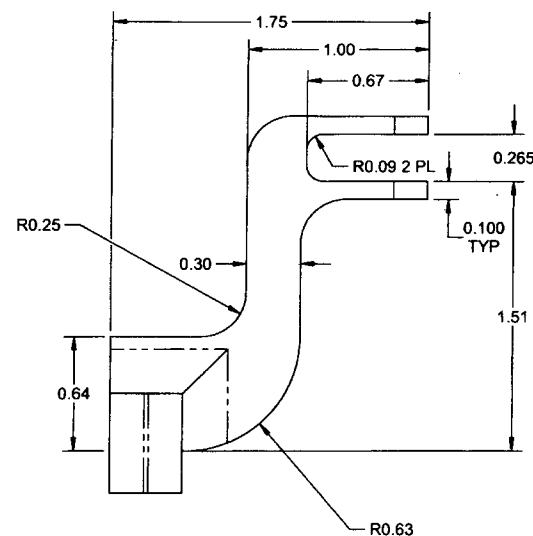
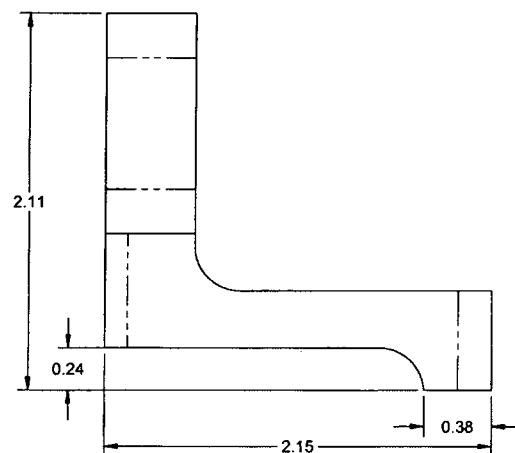
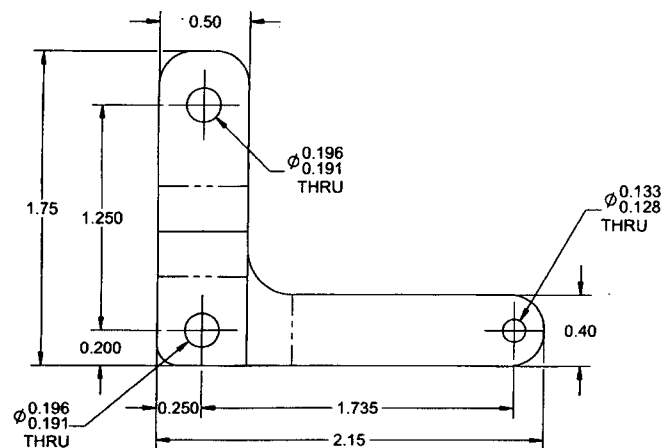
NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DWG FILE "D4522-9-RevB.STP"

D4522-9 VERTICAL SWING ARM

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DESIGN	RP	DART AEROSPACE LTD	
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MFG. APPR.		D4522	SHEET 12 OF 23
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DE APPR.		DOOR LATCH ASSY (412)	NTS
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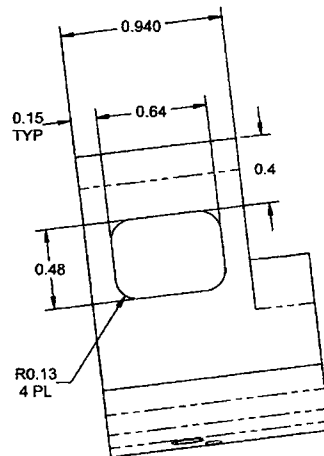
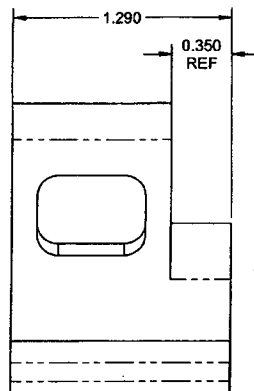
NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.19 lbs
- 8) PROFILE PER DWG FILE "D4522-10-RevB.STP"

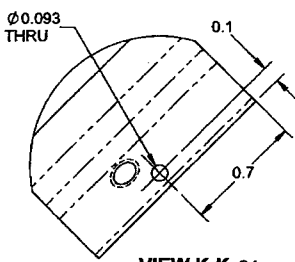
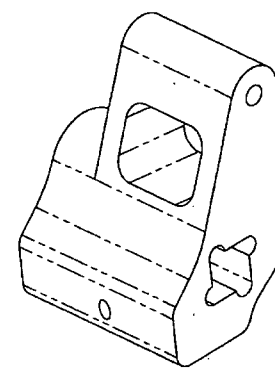
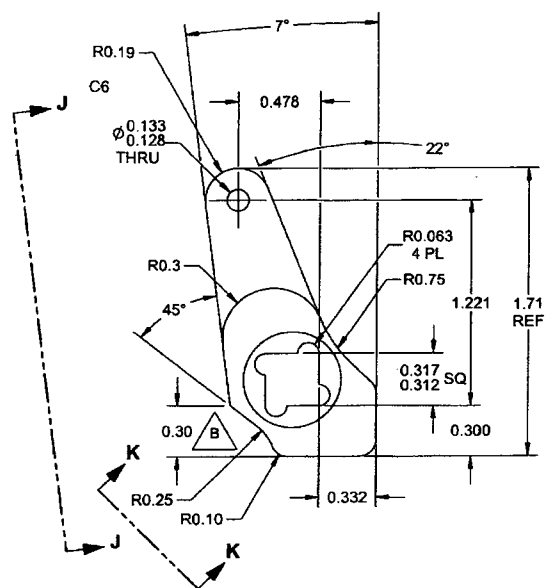
D4522-10 VERTICAL SWING ARM

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MFG. APPR.	<i>[Signature]</i>	D4522	SHEET 13 OF 23
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR LATCH ASSY (412)	NTS
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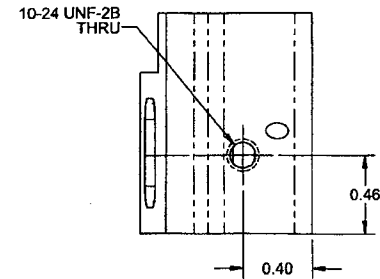
RELEASE
2012-06-13
[Signature]



VIEW J-J C4



VIEW K-K C4



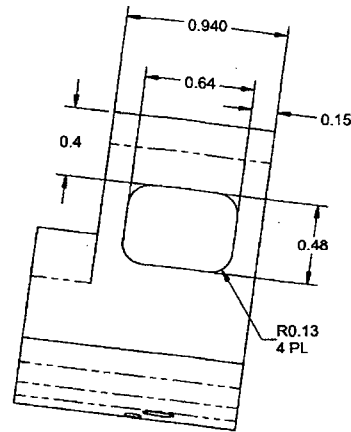
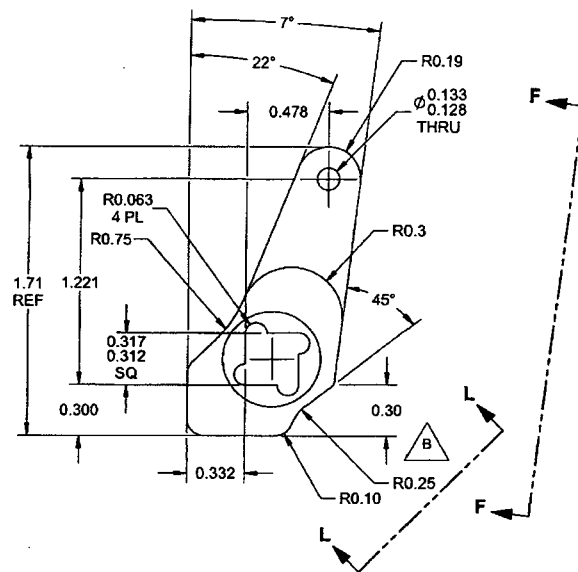
NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.14 lbs
- 8) PROFILE PER DWG FILE "D4522-11-RevB.STP"

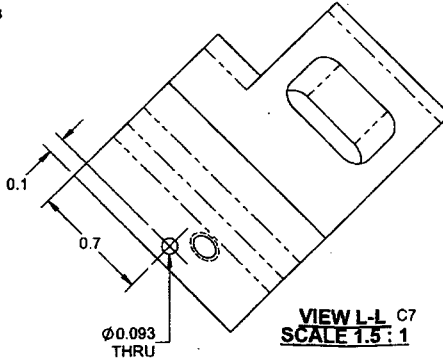
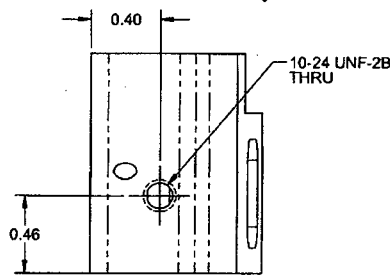
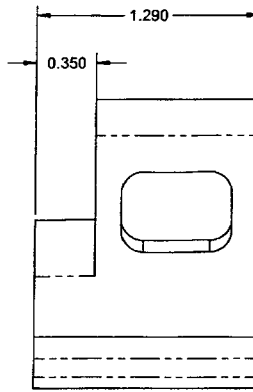
D4522-11 HANDLE SHAFT ARM

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MFG. APPR.		D4522	SHEET 14 OF 23
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DE APPR.		DOOR LATCH ASSY (412) NTS	
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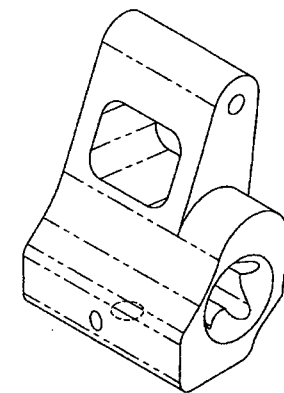
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2012-06-13
143



VIEW F-F C7



VIEW L-L C7
SCALE 1.5:1



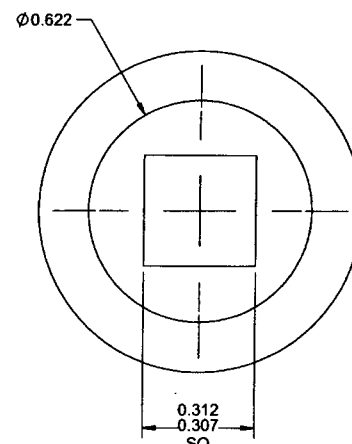
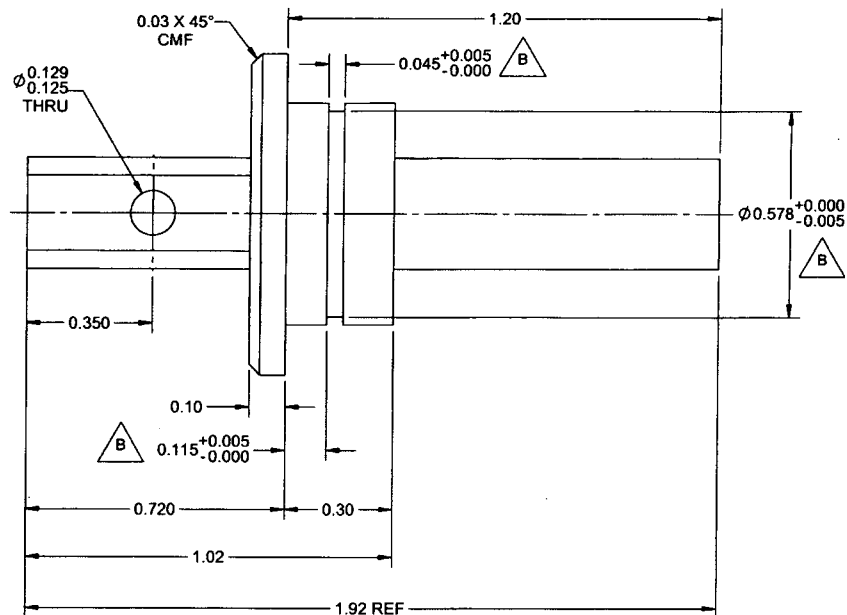
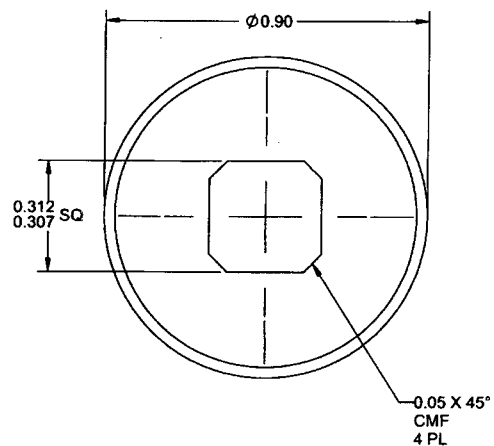
RELEASED
2012-06-13

NOTES:

- 1) MATERIAL: AISI 303 SS BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS BAR OR PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.14 lbs
- 8) PROFILE PER DWG FILE "D4522-12-RevB.STP"

D4522-12 HANDLE SHAFT ARM

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO. D4522	REV. B
MFG. APPR.			SHEET 15 OF 23
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DATE	12.04.17		



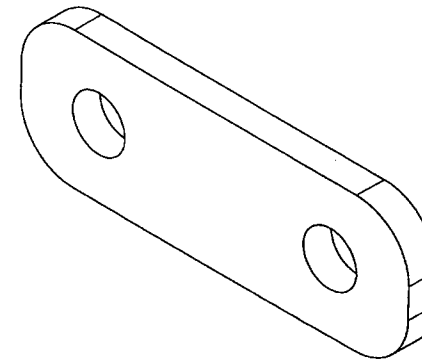
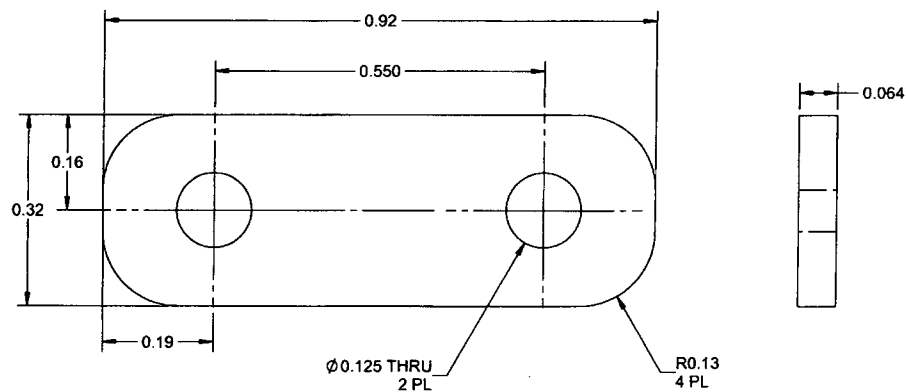
NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582
 REF DART SPEC M303R1.00 OR
 AISI 304/316 SS ROUND BAR PER ASTM A276
 REF DART SPEC M304R1.00
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6
- 7) WEIGHT: 0.08 lbs

D4522-13 HANDLE SHAFT ADAPTER

RELEASE
 2012-06-13

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MFG. APPR.		D4522	SHEET 16 OF 23
APPROVED		TITLE	SCALE
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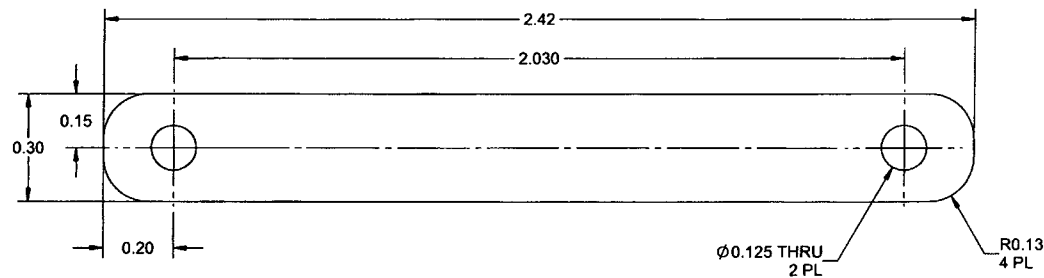
D4522-17 LINKAGE

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2012-06-13

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, ANNEALED, 2B FINISH
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.01 lbs

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MFG. APPR.	<i>[Signature]</i>	D4522	SHEET 17 OF 23
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR LATCH ASSY (412)	NTS
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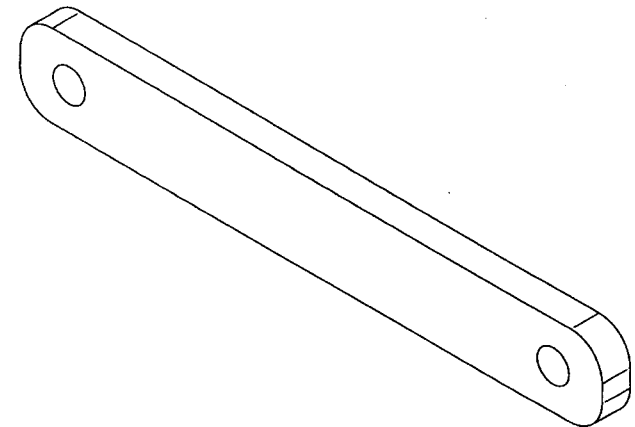
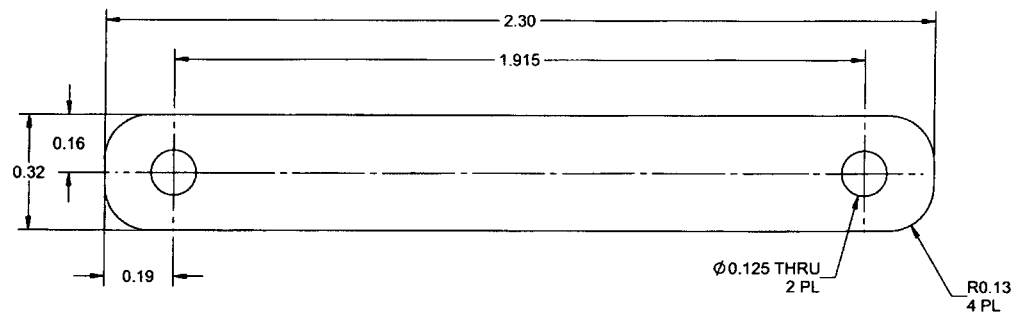
D4522-19 LINKAGE

RELEASED
2012-06-13

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, ANNEALED, 2B FINISH
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI.044 6.6 OR 6.7
- 7) WEIGHT: 0.01 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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D4522-21 LINKAGE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, ANNEALED, 2B FINISH
REF DART SPEC M304S12GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI.044.6.6 OR 6.7
- 7) WEIGHT: 0.02 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	W	DRAWING NO.	REV. B
MFG. APPR.	W	D4522	SHEET 19 OF 23
APPROVED	W	TITLE	SCALE
DE APPR.	W	DOOR LATCH ASSY (412)	NTS.
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2012-06-13
W

8 7 6 5 4 3 2 1

D

D

C

C

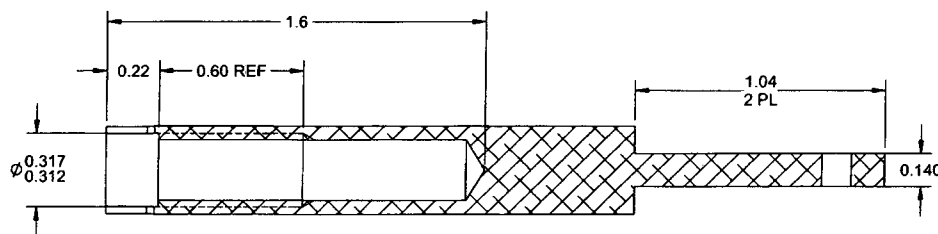
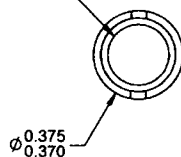
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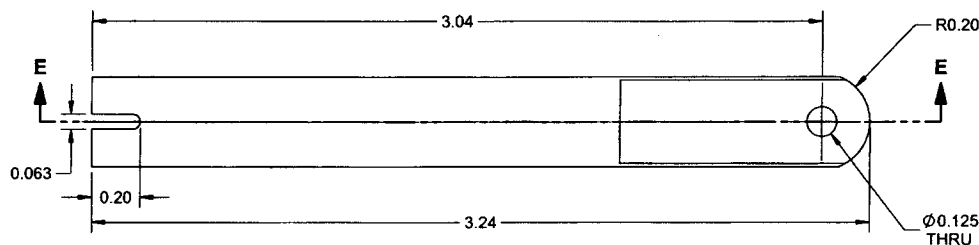
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5/16-18 UNC-2B
0.60 DP



SECTION E-E



D4522-25 LATCH SHAFT

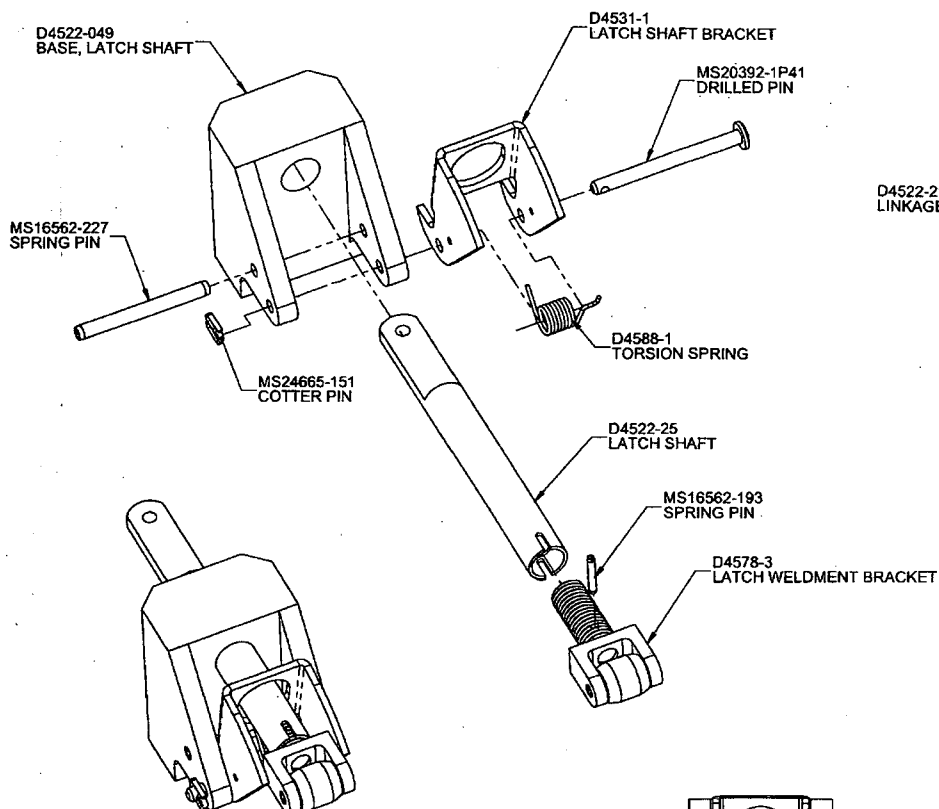
NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A582
REF DART SPEC M303B OR
AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART-QSI-044-6.6 OR 6-7
- 7) WEIGHT: N/A

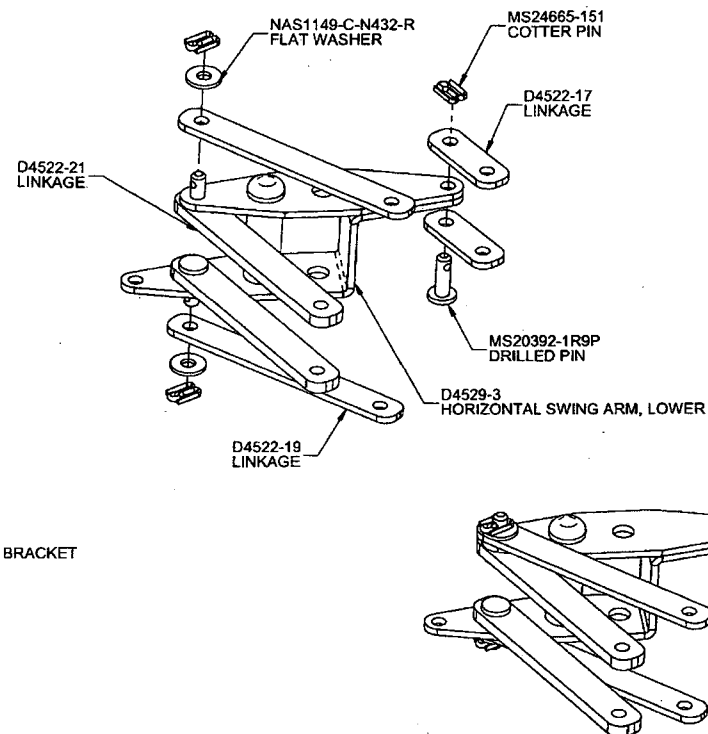
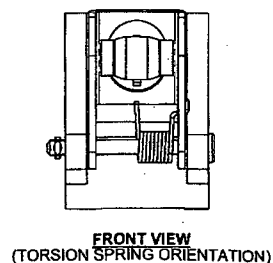
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MFG. APPR.	<i>[Signature]</i>	D4522	SHEET 20 OF 23
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR LATCH ASSY (412)	
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8 7 6 5 4 3 2 1



RECOMMENDED ASSEMBLY DETAIL #1
(LATCH SUB-ASSEMBLY)



RECOMMENDED ASSEMBLY DETAIL #2
(LINKAGE SUB-ASSEMBLY)

RELEASED
R 2012-06-13

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	AP	DRAWING NO. D4522	REV. B
MFG. APPR.	AP		SHEET 21 OF 23
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	DOOR LATCH ASSY (412)	NTS
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D4522-047
BASE, VERTICAL SWING ARM

MS20392-2R41P
DRILLED PIN

MS24665-155
COTTER PIN

D4522-1
BASE PLATE, OEM (LH)

MS16624-4062
EXTERNAL RETAINING RING

MS24671-14
SCREW, FL-HD, HEX, #8

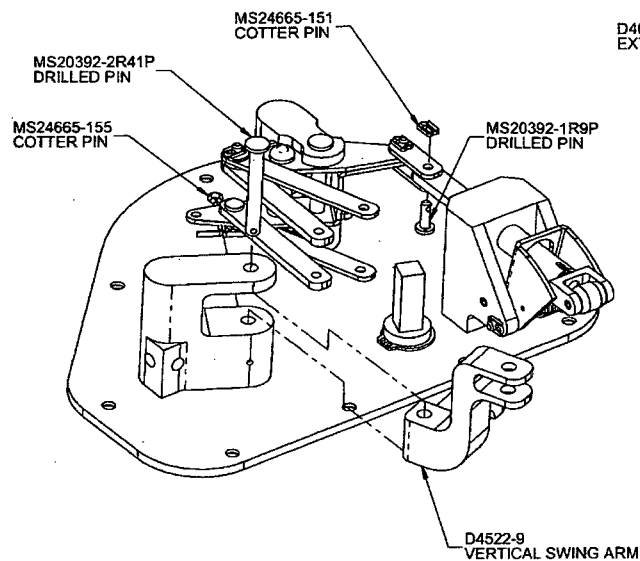
D4522-13
HANDLE SHAFT ADAPTER

RECOMMENDED ASSEMBLY DETAIL #3
(MAIN COMPONENTS TO BASE PLATE)

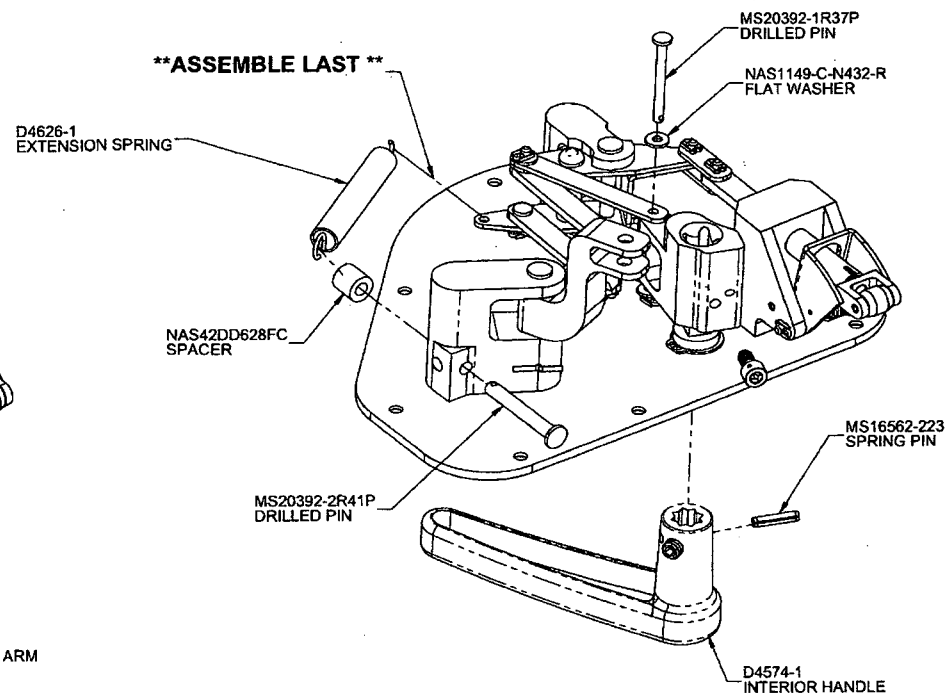
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2012-06-13

(D4522-041 SHOWN)

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MFG. APPR.	<i>[Signature]</i>	D4522	SHEET 22 OF 23
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR LATCH ASSY (412)	NTS
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RECOMMENDED ASSEMBLY DETAIL #4
(VERTICAL SWING ARM, TENSION SPRING, LATCH LINKAGE)



RECOMMENDED ASSEMBLY DETAIL #5
(HORIZ SWING ARM & HANDLE)

RELEASED
R 2012-06-13
(D4522-041 SHOWN)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 23 OF 23
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DE APPR.		DOOR LATCH ASSY (412)	NTS
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